

**AMENDMENTS TO THE CLAIMS**

1. (Currently Amended) A method for yielding transient solutions for a film-blowing process by using a film-blowing process model wherein which comprises continuously extruding a polymer melt ~~is continuously extruded~~; in the presence of air, through an annular die, in both an axial and circumferential direction, simultaneously, said axial direction being produced by the axial extension imposed by the drawing force of nip rolls and the circumferential direction being produced by the air pressure inside the extended polymer melt whereby to produce a biaxially oriented film, ~~is produced~~ wherein the following governing equations concerning the viscoelasticity and cooling characteristics of the film are first solved; and then, then changing, through coordinate transformation, a free-end-point problem ~~is changed~~ into a fixed-end-point problem; and finally, [[by]] introducing Newton's method and OCFE (Orthogonal Collocation on Finite Elements), Elements to obtain the transient solution for the film blowing process is obtained:

Equations:

$$\frac{\partial}{\partial t} \left( rw \sqrt{1 + \left( \frac{\partial r}{\partial z} \right)^2} \right) + \frac{\partial}{\partial z} (rwv) = 0, \quad (1)$$

Where,

$$t = \frac{\bar{t}\bar{v}_0}{\bar{r}_0}, \quad z = \frac{\bar{z}}{\bar{r}_0}, \quad r = \frac{\bar{r}}{\bar{r}_0}, \quad v = \frac{\bar{v}}{\bar{v}_0}, \quad w = \frac{\bar{w}}{\bar{w}_0}$$

Axial direction:

$$\frac{2rw[(\tau_{11} - \tau_{22})] + 2r\sigma_{surf}}{\sqrt{1 + (\partial r / \partial z)^2}} + B(r_F^2 - r^2) - 2C_{gr} \int_0^{z_L} rw \sqrt{1 + (\partial r / \partial z)^2} dz - 2 \int_0^{z_L} r T_{drag} dz = T_z \quad (2)$$

Where,

$$T_z = \frac{\bar{T}_z}{2\pi\eta_0\bar{w}_0\bar{v}_0}, \quad B = \frac{\bar{r}_0^2 \Delta P}{2\eta_0\bar{w}_0\bar{v}_0},$$
$$\Delta P = \frac{A}{\int_0^{z_L} \pi \bar{r}^2 dz} - P_a, \quad \tau_{ij} = \frac{\bar{\tau}_{ij}\bar{r}_0}{2\eta_0\bar{v}_0}$$

$$C_{gr} = \frac{\rho g \bar{r}_0^2}{2\eta_0\bar{v}_0}, \quad T_{drag} = \frac{\bar{T}_{drag}\bar{r}_0^2}{2\eta_0\bar{v}_0\bar{w}_0}, \quad \sigma_{surf} = \frac{\bar{\sigma}_{surf}\bar{r}_0}{2\eta_0\bar{v}_0\bar{w}_0}$$

Circumferential direction:

$$B = \left( \frac{[-w(\tau_{11} - \tau_{22}) + 2\sigma_{surf}](\partial^2 r / \partial z^2)}{[1 + (\partial r / \partial z)^2]^{3/2}} + \frac{w(\tau_{33} - \tau_{22}) + 2\sigma_{surf}}{\tau \sqrt{1 + (\partial r / \partial z)^2}} - C_g \frac{\partial r / \partial z}{\sqrt{1 + (\partial r / \partial z)^2}} \right) \quad (3)$$

Constitutive Equation:

$$K\tau + De \left( \frac{\partial \tau}{\partial t} + v \cdot \nabla \tau - L \cdot \tau - \tau \cdot L^T \right) = 2 \frac{De}{De_0} D, \quad (4)$$

where  $K = \exp[\varepsilon De \operatorname{tr} \tau]$ ,  $L = \nabla v - \xi D$ ,  $2D = (\nabla v + \nabla v^T)$ ,  $De_0 = \frac{\lambda \bar{v}_0}{r_0}$ ,  $De = De_0 \exp \left[ k \left( \frac{1}{\theta} - 1 \right) \right]$ .

Energy Equation:

$$\frac{\partial \theta}{\partial t} + \frac{v}{\sqrt{1 + (\partial r / \partial z)^2}} \frac{\partial \theta}{\partial z} + \frac{U}{w} (\theta - \theta_c) + \frac{E}{w} (\theta^4 - \theta_\infty^4) = 0, \quad (5)$$

Where,

$$\theta = \frac{\bar{\theta}}{\theta_0}, \quad \theta_c = \frac{\bar{\theta}_c}{\theta_0}, \quad \theta_\infty = \frac{\bar{\theta}_\infty}{\theta_0}, \quad U = \frac{\bar{U}r_0}{\rho C_P \bar{w}_0 \bar{v}_0},$$

$$E = \frac{\varepsilon_m \sigma_{SB} \bar{\theta}_0^4 r_0}{\rho C_P \bar{w}_0 \bar{v}_0 \theta_0}$$

Boundary conditions:

$$v = w = r = \theta = 1, \quad \tau = \tau_0 \quad \text{at } z = z_0, \quad (6a)$$

$$\frac{\partial r}{\partial t} + \frac{\partial r}{\partial z} \frac{v}{\sqrt{1 + (\partial r / \partial z)^2}} = 0, \quad \frac{v}{\sqrt{1 + (\partial r / \partial z)^2}} = D_R,$$

$$\theta = \theta_F \quad \text{at } z = z_F. \quad (6b)$$

wherein,  $r$  denotes the dimensionless bubble radius,  $w$  the dimensionless film thickness,  $v$  the dimensionless fluid velocity,  $t$  the dimensionless time,  $z$  the dimensionless distance coordinate,  $\Delta P$  the air pressure difference between inside and outside the bubble,  $B$  the dimensionless pressure drop,  $A$  the air amount inside the bubble,  $P_a$  the atmospheric pressure,  $T_z$  the dimensionless axial tension,  $\eta_0$  the zero-shear viscosity,  $C_{gr}$  the gravity coefficient,  $T_{drag}$  the aerodynamic drag,  $\sigma_{surf}$  the surface tension,  $\theta$  the dimensionless film temperature,  $\tau$  the dimensionless stress tensor,  $D$  the dimensionless strain rate tensor,  $\varepsilon$  and  $\xi$  the Phan Thien-Tanner (PTT) model parameters,  $De$  the Deborah number,  $\theta_0$  the zero-shear viscosity,  $K$  the dimensionless activation energy,  $\lambda$  the fluid relaxation time,  $U$  the dimensionless heat transfer coefficient,  $E$  the dimensionless radiation coefficient,  $k_{air}$  the thermal conductivity of cooling air,

$\rho_{air}$  the density of cooling air,  $\eta_{air}$  the viscosity of cooling air,  $v_c$  dimensionless cooling air velocity,  $\alpha$  and  $\beta$  parameters of heat transfer coefficient relation,  $\theta_c$  the dimensionless cooling-air temperature,  $\theta_\infty$  the dimensionless ambient temperature,  $\epsilon_m$  the emissivity,  $\sigma_{SB}$  the Stefan-Boltzmann constant,  $\rho$  the density,  $C_p$  the heat capacity,  $D_R$  the drawdown ratio; and wherein

the assumption was made that no deformation occurred in the film past a freezeline at the boundary conditions; overbars denote the dimensional variables; subscripts 0, F and L denote the die exit, the freezeline conditions and the nip roll conditions, respectively; and subscripts 1, 2 and 3 denote the flow direction, normal direction, and circumferential direction, respectively.

2. (Previously Presented) The method for yielding transient solutions for the film-blowing process by using a film-blowing process model according to claim 1, wherein a non-isothermal process model is a numerical scheme for yielding transient solutions for the film-blowing process, which has three multiplicities.

3. (Currently Amended) The method for yielding transient solutions for the film-blowing process by using a film-blowing process model wherein which comprises providing a nonlinear stabilization analysis method of the process is provided that which utilizes the temporal pictures obtained from the numerical scheme [[in]] of Claim 1.

4. (Currently Amended) The method for yielding transient solutions for the film-blowing process by using a film-blowing process model according to claim 1, which comprises optimizing wherein a method is provided for the optimization of the process which is obtained by the use of using a sensitivity analysis of the relative effects affecting the stability of each process variable through a transient solution, which was calculated and yielded in the course of deduction of the transient solutions.

Claim 5 (Cancelled)

6. (Currently Amended) An apparatus for the optimization and stabilization of a film-blowing apparatus utilizing the numerical scheme as defined in claim 1, wherein which comprises

~~means are provided for introducing a polymer melt and pressurized air through an annular die where it is die,~~

means for continuously extruded extruding the polymer melt in both an axial and circumferential direction,

wherein nip rollers operatively associated with the extruded polymer melt are provided to produce a drawing force for achieving axial extension of the polymer melt, and

[[the]] means for applying pressurized air is utilized to the polymer melt to achieve the expansion of the melt in the circumferential direction, whereby a biaxially oriented film is produced.